

Date: Wednesday, 02/04/2008 3:35:42 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 38324		
Estimate Number	: 12705		
P.O. Number	:	Part Number	: D35723
This Issue	: 02/04/2008 S.O. No. :	Drawing Number	: D3572 REV.C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 32172	Material	:
Written By	: <u>Jul 08.04.07</u>	Due Date	: 15/04/2008 Qty: 40 Um: Each
Checked & Approved By	:		
Comment	: Est Rev.A New Issue 07-02-07 JLM est rev B rev.B dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X01000 1.500 x .625" 6061-T6 Bar .50" x 1.0"	
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Jul 08.04.07
 .625" THIS BATCH ONLY.

Comment: Qty.: 0.0893 f(s)/Unit Total: 3.5700 f(s) → 5 feet of (M107436) (guaranteed)

6061-T6 Bar .500" x 1.00"

Batch: M107436

M101549

1.6 sqf.

→ 2 feet SA

08/04/07

2.0	BAND SAW	BAND SAW
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20" = 1.6'
Jul 08.04.07



Comment: BAND SAW

Cut blank 1.500" long

SA
08/04/07

SA
08/04/07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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(40)

Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA685 Rev: A & Dwg D3572 Rev: C

2-Deburr per dwg D3572

H.A.F.M.R 08/04/08 SA 08/04/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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(40)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/04/08

H.A.F.M.R SA 08/04/07

SA 08/04/07

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EC 08.04.08

40

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3572 - 3 PAR #: N/A Fault Category: Predefined Parts NCR: (Yes) No DQA: D Date: 08/04/15
(D412-702) QA: N/C Closed: D Date: 08/04/15

NCR: <u>38324</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.04.08</u>	<u>1,2</u>	<u>40 Blanks were cut in</u> <u>with the</u> <u>wrong grain direction.</u>	<u>[Signature]</u> <u>08/04/08</u>	<u>Scrap and destroy</u> <u>Quarantine and Red Tag</u> <u>table Blank in Box</u> <u>AND re cut to Dwg. 3572</u>	<u>[Signature]</u> <u>08/04/08</u>	<u>[Signature]</u> <u>08/04/08</u>	<u>[Signature]</u> <u>08/04/08</u>	<u>[Signature]</u> <u>08/04/08</u>
			<u>[Signature]</u> <u>08/04/08</u>	<u>Have who to defect the</u> <u>Grain Direction for cutting</u> <u>Blanks</u>		<u>[Signature]</u> <u>08/04/08</u>	<u>[Signature]</u> <u>08/04/08</u>	<u>[Signature]</u> <u>08/04/08</u>

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 3:35:42 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 38324

Part Number: D35723

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PATD.

AS 08/04/09 *(X45)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/14 *(X45)*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-11

W

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

x

First Article

11


Prototype

[illegible]

Measured by:	SD
Date:	08/04/07

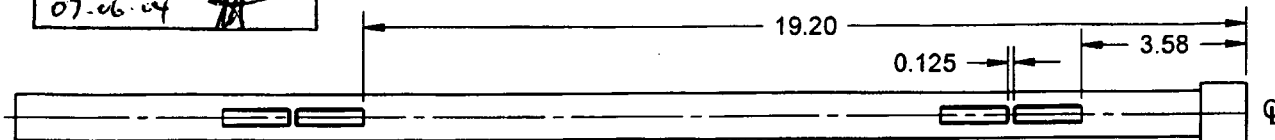
Audited by:	S.F.
Date:	08/04/07

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 1 OF 2
DATE 07.06.01	TITLE GUIDE ASSEMBLY	SCALE 1:4	
REV	DATE	DESCRIPTION	
A	07.03.29	NEW ISSUE	
B	07.04.20	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	
C	07.06.01	REMOVE D3572-7	

RELEASED07.06.01 *H*D3572-3 GUIDE
(4 PLACES)

3/16

4X

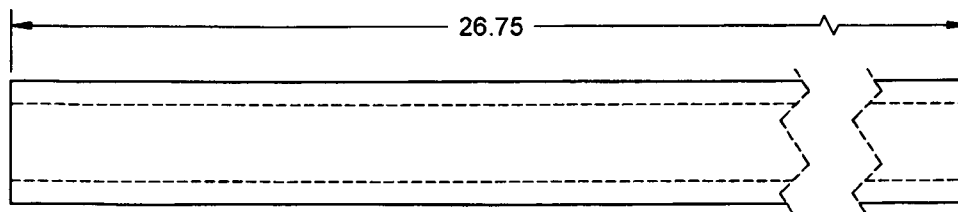
D3572-1 TUBE

D3572-041 GUIDE ASSEMBLY

D3572-5 BRACKET

D3572-041 NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3572-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) WELD PER DART QSI 004

**D3572-1 TUBE**

0.188 (REF) Ø 1.000 (REF)

D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T1.000W.188)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

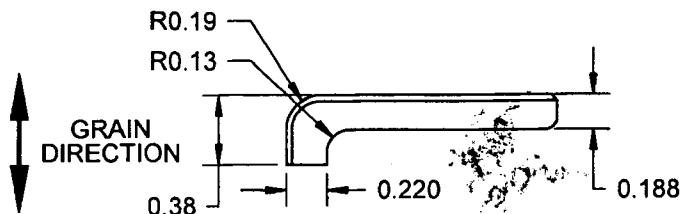
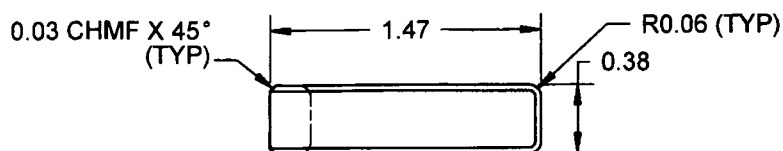
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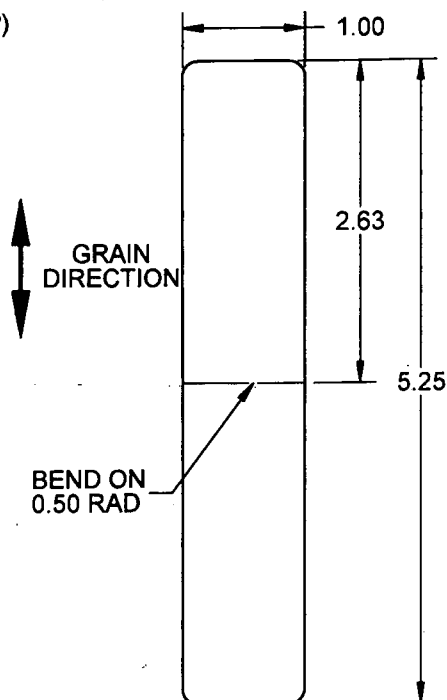
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WORK ORDER
NO 38327

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3572	REV. C SHEET 2 OF 2
DATE 07.06.01		TITLE GUIDE ASSEMBLY	SCALE 2:3

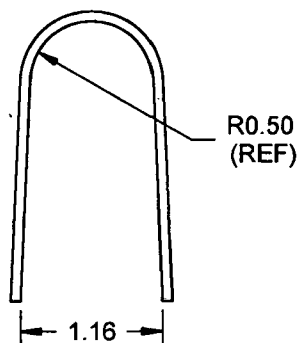
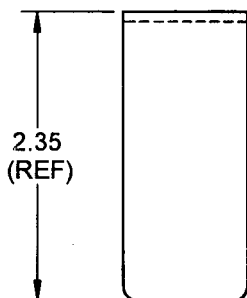


1 **D3572-3 GUIDE**



BEND ON
0.50 RAD

2 **D3572-5F FLAT PATTERN**



D3572-5 BRACKET
(MAKE FROM D3572-5F)

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. _____

RELEASED

07.06.01 *H*

D3572-3/-5 NOTES:

- 1) D3572-3 MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160) (REF DART SPEC M6061T6B)
- 2) D3572-5 MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11
OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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